



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3009-3
Job Sheet 168475



Part No: D3009-3

Part Name: Cup



Part Weight: 0 lbs

Job Created: 11/15/17

Due Date: 11/23/17

Type: Stock

Ship Via:

Job Qty: 60 ea

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		11/22/17	0.00	0.00	Start Up Machining		
100	Hardinge	60 pcs		11/23/17	0.00	7.10	Hardinge		
120	QC	60 pcs		11/23/17	0.00	0.00	QC8		
130	Packaging	60 pcs		11/23/17	0.00	0.00	Packaging3		
140	QC21-SA	60 Ea		11/23/17	0.00	0.00	QC21		

Part Op 100 - 1-TURN AS PER FOLIO FA130 & DWG D3009

Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION WA002

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304R1.000	3	1	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084		
6	Cup	0.353Inches ± 0.010	0.363 0.343		
7	Cup	0.063Inches ± 0.010	0.073 0.053		
8	Cup	0.032Inches ± 0.010	0.042 0.022	Radius	
9	Cup	45.000Degrees ± 0.000	45.000 45.000	Angle	

QQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>168475</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3009-3</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Large Fab ☐	Composite ☐	Supplier ☐		

Date: 17-11-24

Step #: 100

QTY Effective: 32

MRB (QS1042) Approval

Description Work Order Deviation
φ .750 dimension is .020" off tolerance
(φ .750 +/- .010)

Disposition

Completed By

Lead hand / Supervisor
Approval Verification
17-11-24

QC / QA Coordinator
Approval

DART
AEROSPACE
S014587

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Hawkesbury, ON K64 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Root	
Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pre	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐



Cup

PART NO:

D3009-3

Revision:

Operation:

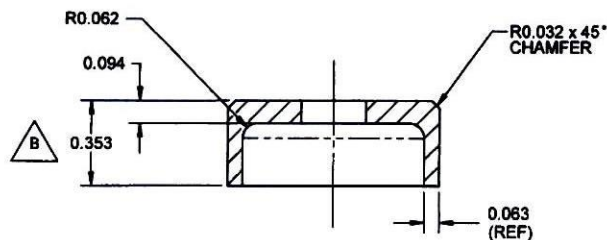
Start up Operation

Change No:

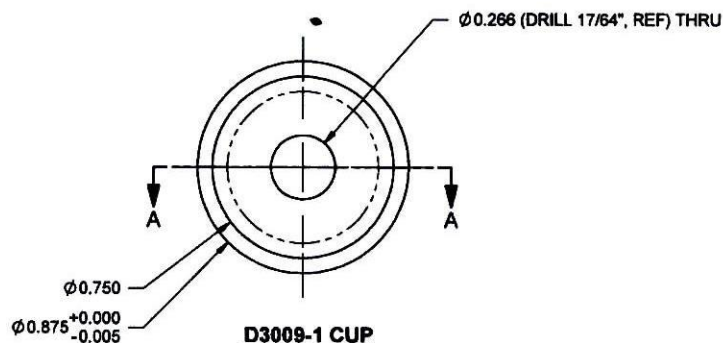
Mfg Date: 11/28/17

Job No: 168475

Power Loss/Surge ☐	Positioned Wrong ☐
Folio/Program ☐	Outside Dimensions ☐
Grain ☒	Over/Under tolerance ☐
Weld ☐	Part Incorrect ☐
Wrong Stock Pulled ☐	Part Lost/Missing ☐
Out of Sequence ☐	Part Moved ☐
Off-set ☐	Drawing ☐
Mislabeled ☐	Finish ☐
Fit/Function ☐	Misread ☐
Misaligned/off center ☐	Turning Sequence ☐



SECTION A-A



D3009-1 CUP

RELEASED
08.01.07

NOV 16 2017

DAS
30
9-89

NO. 168475
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

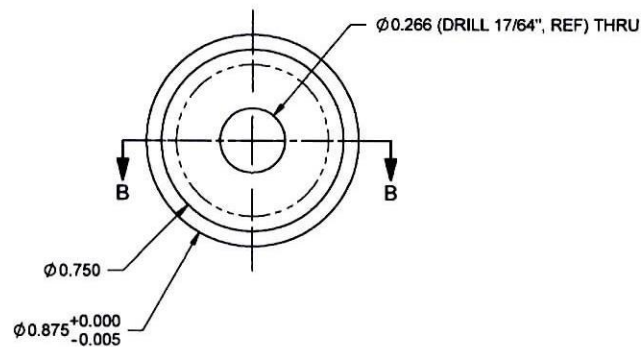
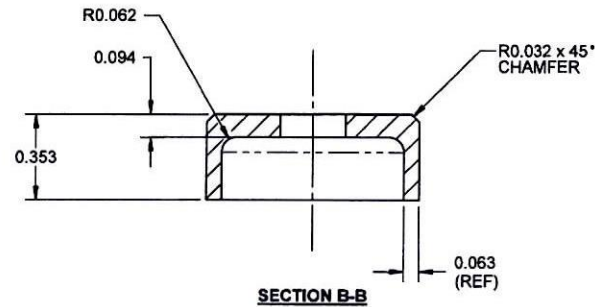
- 1) MATERIAL: AISI 1018-1025 ROUND BAR (REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	REDRAW/REFORMAT DWG. D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3009
REV. B
SHEET 1 OF 2
TITLE CUP
SCALE 2:1

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D3009-3 CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASE
06-01-07-10

DESIGN	921	DART AEROSPACE LTD	
DRAWN	921	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.	13	D3009	SHEET 2 OF 2
APPROVED	13	TITLE	SCALE
DE APPR.	13	CUP	2:1
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